

Date: Monday, 10/22/2007 3:41:46 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: FITTING		
Job Number	: 35284			Part Number	: D32161		
Estimate Number	: 10869			Drawing Number	: D3216 REV A		
P.O. Number	:			Project Number	: N/A		
This Issue	: 10/22/2007 S.O. No. :			Drawing Revision	: A		
Prsh Rev.	: NC			Material	:		
First Issue	: / / Type : SMALL /MED FAB			Due Date	: 11/5/2007		
Previous Run	: 30615			Qty:	70		
Written By	: <u>HB 07-10-23</u>			Um:	Each		
Checked & Approved By							
Comment	: Est: A 03.10.28 New Issue KJ/RF						
	: Est Rev:B Now on Waterjet 06-07-03 JLM						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S11GA	304/316 .125 Sheet  2.2348
		Comment: Qty.: 0.0302 sf(s)/Unit Total : 1.8144 sf(s) 304/316 .125 Sheet (M304S0125) Batch: M104 934 HB 07-10-24
2.0	WATER JET	FLOW WATER JET
		Comment: FLOW WATER JET 1-Cut as per Dwg D3216 Dwg Rev: A Prog Rev: A HB 07-10-24
		2-Deburr if necessary
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE  HB 07-10-24
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
		Comment: SECOND CHECK
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1  Deburr HB 07/0/29
		Comment: SMALL & MEDIUM FAB RESOURCE 1 2. Tumble until parts have a polished finish.
		SAO 07-10-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 10/22/2007 3:41:47 PM  
User: \*Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FITTING

Job Number: 35284

Part Number: D32161

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



coated

Comment: INSPECT WORK TO CURRENT STEP

07/10/30 (X74)

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST77

(X74)

07/10/31 KS

(C)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



07.10.31 (J)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 87-10-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

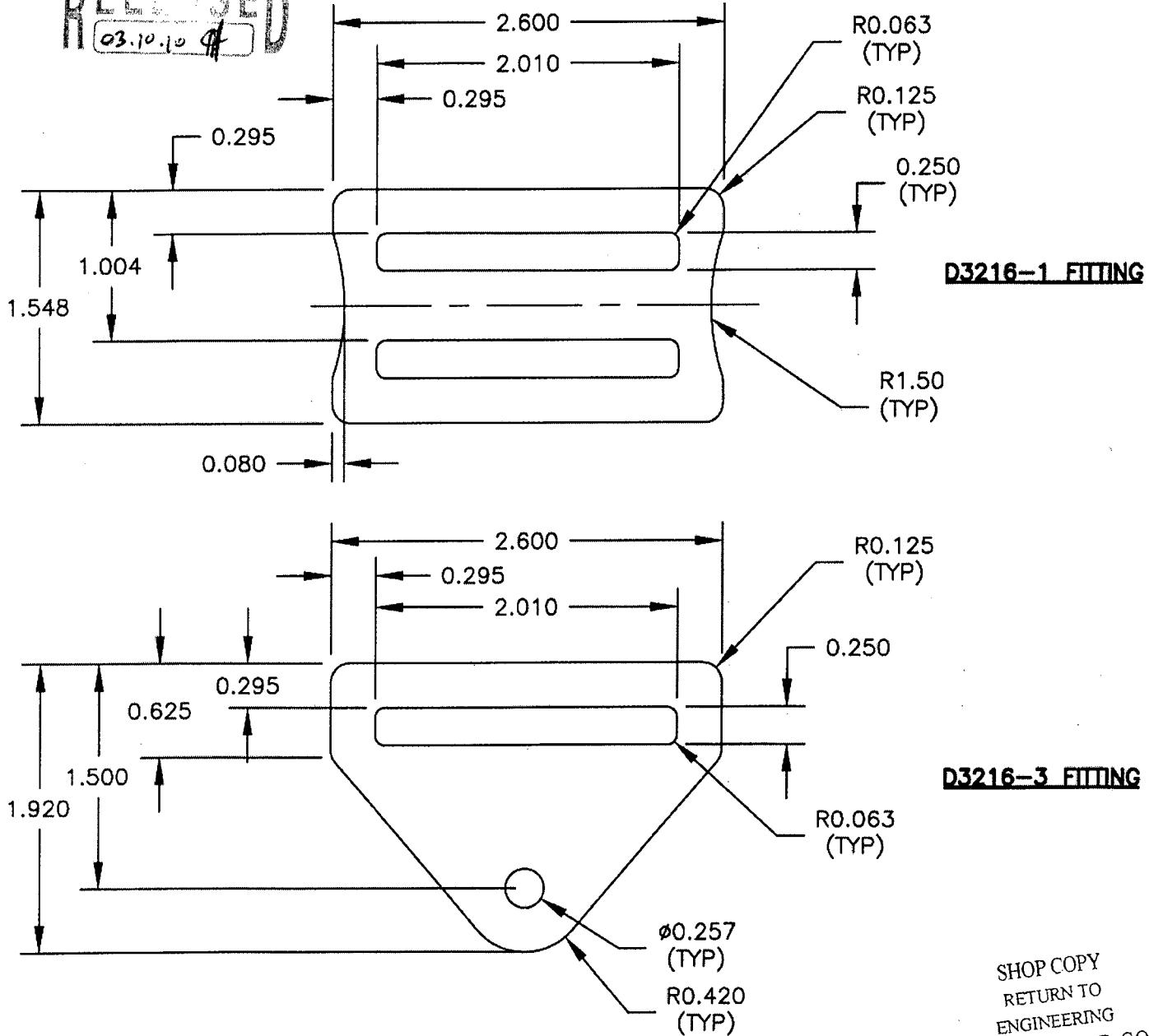
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3216	SHEET 1 OF 1
DATE	TITLE		SCALE
03.09.26	FITTING		1:1
A	03.09.26	NEW ISSUE	

**RELEASED**  
03.10.10 9f**D3216-1/-3 FITTING**

- 1) MATERIAL: AISI 304/316 PLATE, 0.125 THICK (REF DART SPEC. M304S11GA)
- 2) FINISH: MOLECRO POLISH
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 35284

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DART AEROSPACE LTD	Work Order:	35284
Description: FITTING	Part Number:	D3216-1
Inspection Dwg: 3216-1 Rev: A		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by: <u>AB</u>	Audited by: <u>SG</u>	Prototype Approval: <u>  /  /  </u>
Date: <u>07-10-24</u>	Date: <u>07/10/24</u>	Date: <u>  /  /  </u>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

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